

Date: Wednesday, 7/11/2007 2:46:26 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE
Job Number	: 33473	Part Number	: D29392
Estimate Number	: 10937	Drawing Number	: D2939 REV C
P.O. Number	:	Project Number	: N/A
This Issue	: 7/11/2007 S.O. No. :	Drawing Revision	: C
Prsht Rev.	: NC	Material	:
First Issue	: / / Type : MACHINED PARTS	Due Date	: 7/30/2007 Qty: 12 Um: Each
Previous Run	: 32385		
Written By	: <u> </u>		
Checked & Approved By	: <u> </u>		
Comment	: Est: B 00.06.26 New DWG rev (mpp 2069) EC Est Rev: C As per Rev C 07-03-19 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101001	7075-T7351 2X6X6.25
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Issue material from stock: 7075-T7351 (QQ-A-250/12)
 Cut Size 2.0" x 6.25" X 6.00" Grain Along 6.00" Length

Batch No: B25342 X 3 B23934 X 9 mk 07/08/05 12

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet

5-Deburr

mk 07/08/05 12

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

mk 07/08/05 12

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

mk 07/08/05 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 33473

Part Number: D29392

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 07/08/07

(12)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M 07 08 09

(12)

7.0

POWDER COATING

POWDER COATING



M1105068



(12x)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-F 07/08/11

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

EFS 07/08/13 (12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

EFS 07/08/13 (12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.08.13

Job Completion



C207/08/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	33473
Description: 206 Saddle, Inboard, Right side	Part Number:	D2939-2
Inspection Dwg: D2939 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.127	0.124	0.126	0.126		
B	0.100	0.140		0.125	0.125	0.126	0.124		
C	0.100	0.140		0.116	0.117	0.116	0.117		
D	0.210	0.230		0.223	0.224	0.225	0.224		
E	1.245	1.255		1.249	1.249	1.250	1.249		
F	1.245	1.255		1.249	1.249	1.250	1.249		
G	2.495	2.505		2.499	2.499	2.506	2.506		
H	0.510	0.515		0.510	0.516	0.520	0.510		
I	1.572	1.582		1.576	1.577	1.577	1.576		
J	2.495	2.505		2.500	2.500	2.499	2.506		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.238	0.238	0.238	0.238		
N	0.100	0.140		0.121	0.121	0.121	0.121		
O	0.540	0.560		0.549	0.550	0.550	0.550		
P	0.490	0.510		0.502	0.501	0.500	0.502		
Q	3.715	3.725		3.718	3.718	3.718	3.718		
R	2.720	2.760		2.740	2.746	2.740	2.746		
S	0.240	0.270		0.256	0.257	0.256	0.256		
T	0.100	0.180		0.138	0.138	0.138	0.140		
U	1.625	1.635		1.628	1.629	1.628	1.629		
V	1.362	1.372		1.366	1.366	1.366	1.366		
W	0.316	0.321		0.320	0.320	0.320	0.320		
X	1.250	1.270		1.261	1.261	1.262	1.260		
Y	1.565	1.585	DT8695 A/B	1.574	1.575	1.574	1.574		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>ML</i>	Audited by: <i>J.F.</i>
Date: <i>07/08/05</i>	Date: <i>07/08/07</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD	Work Order:	33473
Description: 206 Saddle, Inboard, Right side	Part Number:	D2939-2
Inspection Dwg: D2939 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.126	0.125	0.124	0.125		
B	0.100	0.140		0.126	0.126	0.126	0.125		
C	0.100	0.140		0.118	0.116	0.119	0.118		
D	0.210	0.230		0.224	0.225	0.224	0.224		
E	1.245	1.255		1.250	1.249	1.249	1.249		
F	1.245	1.255		1.250	1.249	1.249	1.249		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.577	1.576	1.576	1.577		
J	2.495	2.505		2.500	2.499	2.500	2.499		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.238	0.238	0.238	0.238		
N	0.100	0.140		0.121	0.121	0.121	0.121		
O	0.540	0.560		0.548	0.550	0.550	0.550		
P	0.490	0.510		0.502	0.502	0.502	0.501		
Q	3.715	3.725		3.718	3.718	3.718	3.718		
R	2.720	2.760		2.740	2.740	2.740	2.740		
S	0.240	0.270		0.257	0.257	0.256	0.256		
T	0.100	0.180		0.140	0.136	0.136	0.138		
U	1.625	1.635		1.628	1.628	1.628	1.628		
V	1.362	1.372		1.366	1.366	1.366	1.366		
W	0.316	0.321		0.320	0.320	0.320	0.320		
X	1.250	1.270		1.260	1.260	1.261	1.261		
Y	1.565	1.585	DT8695 A/B	1.574	1.574	1.574	1.574		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>emb</i>
Date:	07/08/05

Audited by:	<i>J.F.</i>
Date:	07/08/07

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

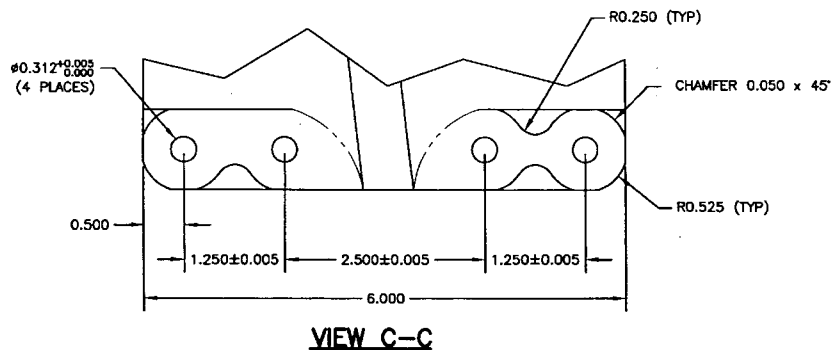
DART AEROSPACE LTD	Work Order:	33473
Description: 206 Saddle, Inboard, Right side	Part Number:	D2939-2
Inspection Dwg: D2939 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.123	0.126	0.125	0.126		
B	0.100	0.140		0.125	0.126	0.126	0.124		
C	0.100	0.140		0.118	0.120	0.119	0.119		
D	0.210	0.230		0.223	0.223	0.223	0.223		
E	1.245	1.255		1.249	1.249	1.249	1.249		
F	1.245	1.255		1.249	1.249	1.249	1.249		
G	2.495	2.505		2.500	2.506	2.500	2.506		
H	0.510	0.515		0.510	0.510	0.516	0.510		
I	1.572	1.582		1.576	1.577	1.577	1.577		
J	2.495	2.505		2.499	2.506	2.506	2.499		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.238	0.238	0.238	0.238		
N	0.100	0.140		0.121	0.121	0.121	0.121		
O	0.540	0.560		0.556	0.550	0.550	0.550		
P	0.490	0.510		0.502	0.502	0.502	0.503		
Q	3.715	3.725		3.718	3.719	3.719	3.718		
R	2.720	2.760		2.740	2.740	2.740	2.740		
S	0.240	0.270		0.256	0.256	0.256	0.255		
T	0.100	0.180		0.140	0.140	0.140	0.140		
U	1.625	1.635		1.628	1.628	1.628	1.628		
V	1.362	1.372		1.366	1.366	1.366	1.366		
W	0.316	0.321		0.326	0.320	0.326	0.320		
X	1.250	1.270		1.260	1.260	1.261	1.260		
Y	1.565	1.585	DT8695 A/B	1.573	1.573	1.573	1.575		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

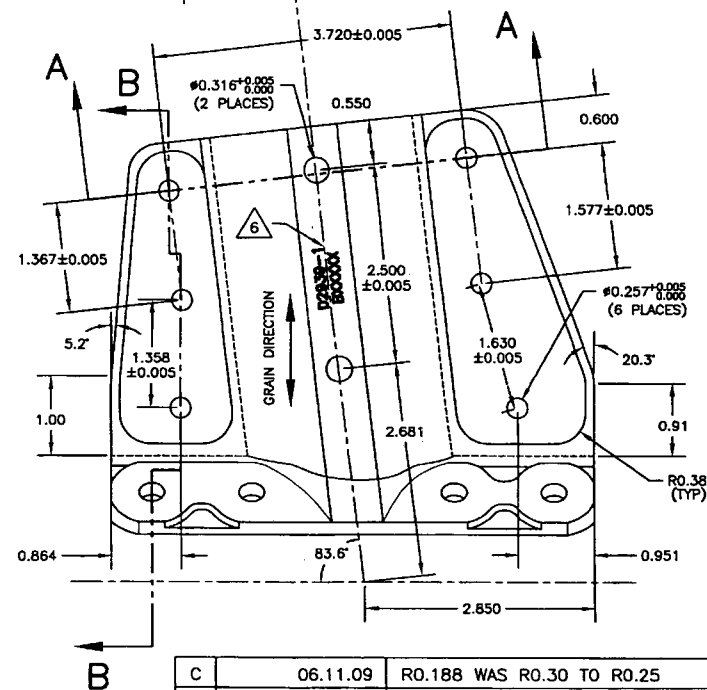
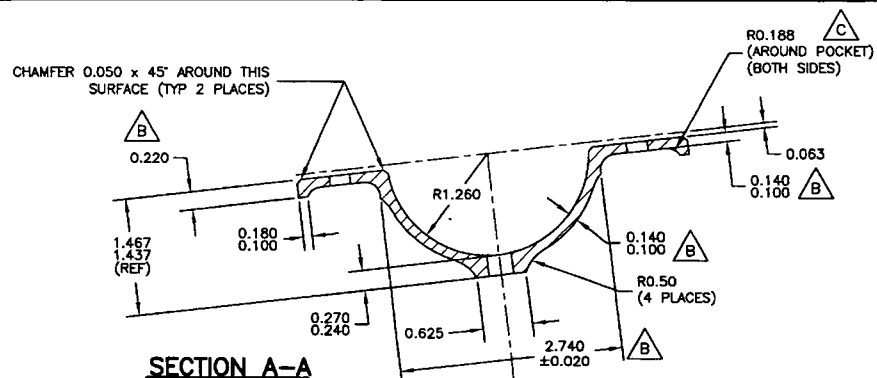
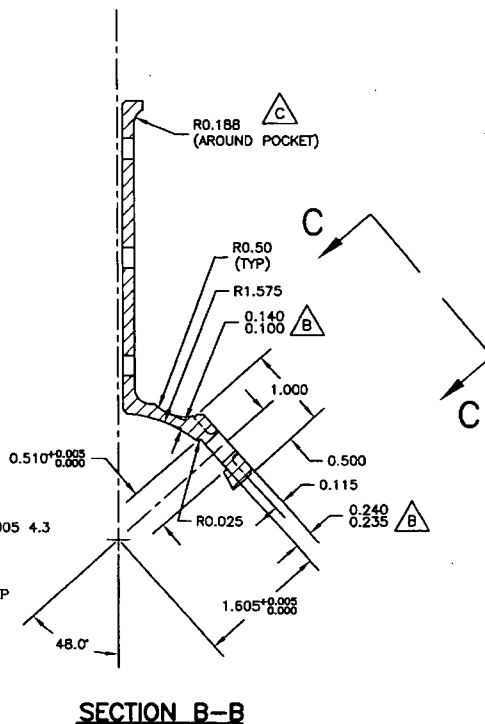
Measured by:	<i>JML</i>	Audited by:	<i>J.F.</i>
Date:	<i>07/08/05</i>	Date:	<i>07/08/07</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>



D2939-1 LH SADDLE (SHOWN)
D2939-2 RH SADDLE (OPPOSITE)

- NOTES:**
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BELLVILLE, VA
CHECKED	APPROVED	DRAWING NO. D2939
DATE	06.11.09	TITLE SADDLE INSIDE
		REV. C SHEET 1 OF 1 SCALE 2:3

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 NO. 33473

07.02.12 #